



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-2708-01
Job Sheet 189243



Part No: RBE350A94-2708-01

Job Qty: 10 pcs

Part Name: Tail Rotor Blade Locking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2708-01 Rev G IPP Rev A 18.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	10 pcs	3/15/19	3/15/19	0.08	2.00	External Load - 1		
							External Load - 2		
							External Load - 3		
							Small Fab - 1		
							Small Fab - 2		A.P.
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	10 pcs	3/15/19	3/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	10 pcs	3/15/19	3/15/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S159534



Part: RBE350A94-2708-01

Job No: 189243

Serial No/Batch: S159534

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 03/06/19

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	ALL
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	10 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	DAS	MAR 08 2019
					QC 21 - FG - 70	

Part Op **100** - (Small Fab) 1-Fabricate lanyard as per DWG. sheet 1 note 7. 2-Assemble as per DWG. sheet 1.
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	20 Ea (2 ea)	100-Small Fab - 1	
90866A030	Wing Nut 5/16" - 18	10 Ea (1 ea)	100-Small Fab - 1	
CL-2-C	Lanyard Wire	15 ft (1.5 ea)	100-Small Fab - 1	
NAS1756-12	Remove Before Flight	10 Ea (1 ea)	100-Small Fab - 1	
RBE350A94-2708-01-01	Slide	10 pcs (1 ea)	100-Small Fab - 1	
RBE350A94-2708-01-15	Rod Assembly	10 pcs (1 ea)	100-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	20	570	0
	90866A030	10	36	0
	CL-2-C	15	389	0
	NAS1756-12	10	394	0
	RBE350A94-2708-01-01	10	32	0
	RBE350A94-2708-01-15	10	5	0

Part Specifications	
Specifications could not be found.	

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Job Sheet 189243



Part No: RBE350A94-2708-01

Job Qty: 10 pcs

Part Name: Tail Rotor Blade Locking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2708-01 Rev G IPP Rev A 18.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	10 pcs	2/15/19		0.08	2.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	10 pcs	2/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	10 pcs	2/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

Plex 1/22/19 10:11 AM Dart.lajeunesse.marie

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	10 pcs	2/15/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

Part Op **100** - (Small Fab) 1-Fabricate lanyard as per DWG. sheet 1 note 7. 2-Assemble as per DWG. sheet 1.
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
26 3896T31	Ferule 1/16 X 3/8" - Aluminum	10 20 Ea (2 ea)	100-Small Fab - 1	5093315
66 90866A030	Wing Nut 5/16" - 18	5 10 Ea (1 ea)	100-Small Fab - 1	5036845
25 CL-2-C	Lanyard Wire	7.5 15 ft (1.5 ea)	100-Small Fab - 1	5119833
141B NAS1756-12	Remove Before Flight	5 10 Ea (1 ea)	100-Small Fab - 1	5134216
RBE350A94-2708-01-01	Slide	5 10 pcs (1 ea)	100-Small Fab - 1	5103797
RBE350A94-2708-01-15	Rod Assembly	5 10 Ea (1 ea)	100-Small Fab - 1	5151303

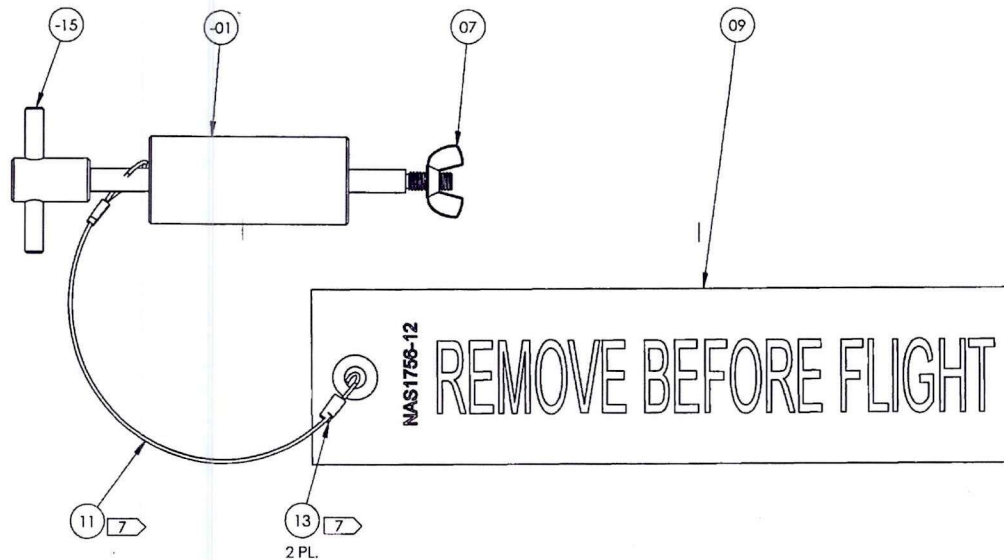
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	20	618	0
	90866A030	10	36	0
	CL-2-C	15	493	0
	NAS1756-12	10	486	0
	RBE350A94-2708-01-01	10	32	0
	RBE350A94-2708-01-15	10	0	0

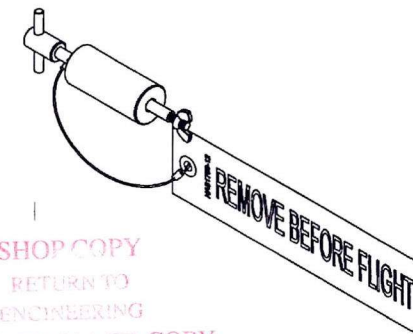
Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	TITLE	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-01	1	RBE350A94-2708-01-01	SLIDE	4	-01 CH'D DIM WAS Ø.402 IS Ø.402 Ø.48 X 90°. -03 CH'D P.F. HOLE WAS Ø.312 TO .3117 P.F. -05 IS Ø.312 TO .3122 P.F. -05, CH'D FINISH WAS BLACK ANODIZE IS BLADE OXIDE		3/10/2014	DPD	GE
-15	1	RBE350A94-2708-01-15	ROD ASSY	5	-13 ADDED TO BOM, ADDED MISSING DIM 2X .88 TO SHT 1.	15-0211	8/14/2015	RJC	JAG
07	1	McMaster#90866A030	WING NUT 5/16"-18	6	UPDATED TO NEW STANDARDS. -03 CH'D THREAD CLASS WAS 2B IS 2A; CH'D DIM WAS Ø.3122/.3116 THRU P.F. -05 IS Ø.3122/.3116 THRU ALL (P.F. -05); ADDED FINISH SPEC.	16-0258	12/5/2016	SM	JAG
09	1	NAS 1756-12	REMOVE BEFORE FLIGHT	G	ASSY -15 ADDED & DIMENSION 2X .88 REMOVED, TEMPLATE UPDATED, McM# ADDED TO CARR-LANE DESCRIPTION, ASSY NOTE ADDED	17-804	01/02/2018	VM	ML
11	AR	CARR-LANE #CL-2-C or McMaster#3461T44	LANYARD 1/16" NYLON COATED						
13	2	McMaster#3896T31	FERRULE 1/16" DIA. x 3/8"						



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189243 MW
1901-22



RBE350A94-2708-01 TAIL ROTOR BLADE LOCKING TOOL

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) CRIMP FERRULES ONTO 12" LONG LANYARD AS SHOWN

DART AEROSPACE		Hawkesbury, Ontario, Canada	
TITLE TAIL ROTOR BLADE LOCKING TOOL			
PART NO. RBE350A94-2708-01		REV G	
TOOL NO. RBE350A94-2708-01		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
INITIALS AND DATE		TOLERANCES:	
DESIGNED BY: VM 01/02/2018		XX ±.005	FRACTIONS ± 1/8
DRAWN BY: VM 01/02/2018		XX ±.01	ANGLES ±.5°
CHECKED BY: VM 01/02/2018		X ±.1	SURFACE ROUGHNESS
MFG REVIEW BY: DD 01/03/2018			
APPROVED BY: ML 01/08/2018		SCALE: NTS	SHEET 1 OF 4
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					